

Work Order ID 90531

90531

Page 1

September-19-12 11:52:15 AM

Item ID: D2600-1-160 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Extrusion Round 3" 206
 Start Date: 9/18/12 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 10/19/12 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12-09-20 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2600	E								

100 0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

17955

a) Extrude as per Dwg D2600 (160" long)

b) Material: 6061-T6

c) Material certification is required.

CL 12/09/20 (80)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

Ensure material certification is attached

0.00

12/1/20 (76)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

September-19-12 11:52:15 AM

Item ID: D2600-1-160 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Extrusion Round 3" 206
 Start Date: 9/18/12 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 10/19/12 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester	0.00 0.00							
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>46</u> <u>Full on 12/10/30 For QC inspection *</u> Memo <u>12/10/30</u>	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

(76)
count

12-10-30
76
12/10/31

12-10-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Picklist Print

September-19-12 11:52:14 AM

Page 1

Work Order ID: 90531

Parent Item: D2600-1-160

Start Date: 9/18/12

Required Date: 10/19/12

Parent Item Name: Extrusion Round 3" 206

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP D: 02.09.05 Added DSK 066 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160P Extrusion Round 3" 206		Purchased	No			110	Each	0.0000	1	80		9/21/12	(76)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18870
 - SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MH-18859
 - SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
 - CARADON INDALEX DIE # MS-18872

SHOWN
RIT
ENCLOSURE
UNCONTINUED
SUBJECT TO CHANGE

WITH
WORK
NO. 90531 ML5
12-09-20

RELEASED
2012-01-11

E	REFORMAT DWG: ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

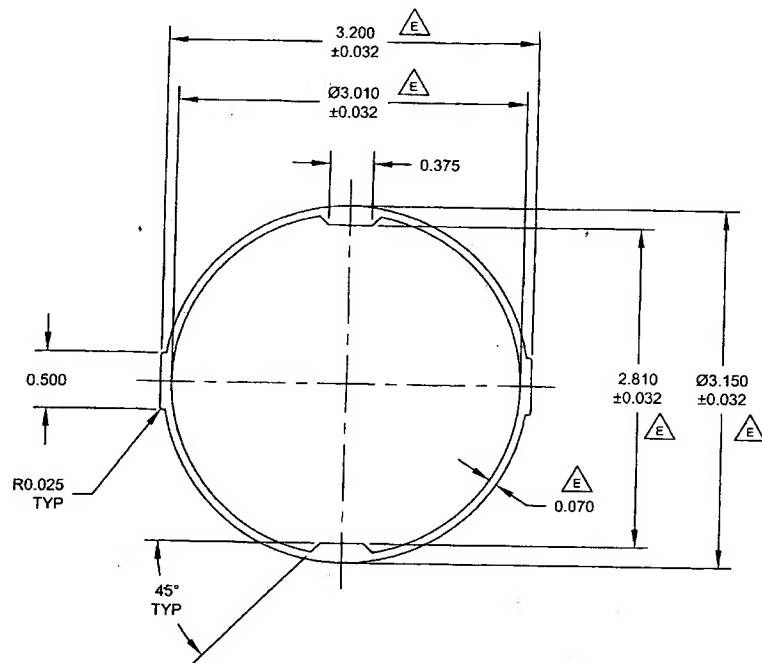
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2600
REV. E
SHEET 1 OF 3

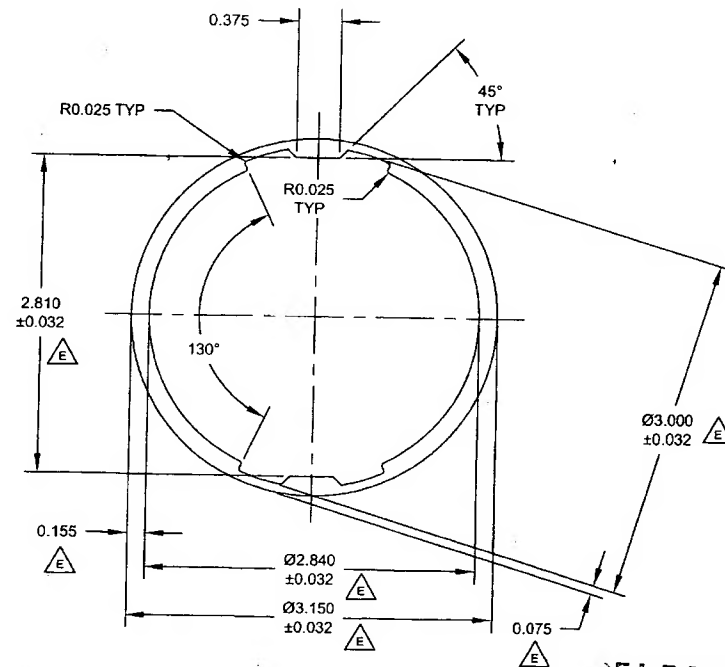
TITLE
EXTRUSION
SCALE
NTS

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90531



D2600-1 EXTRUSION

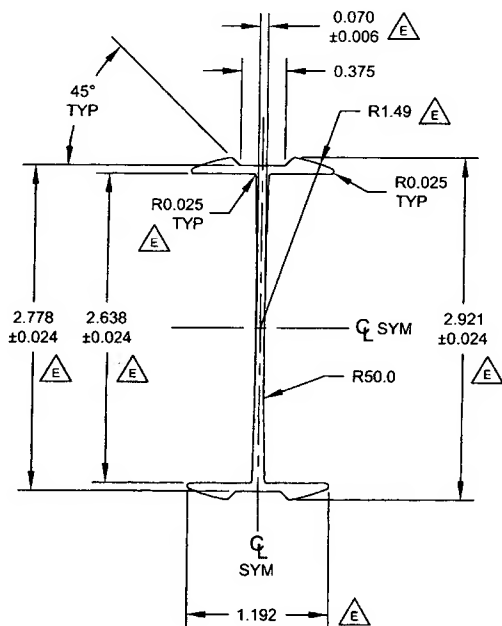


D2600-3 EXTRUSION

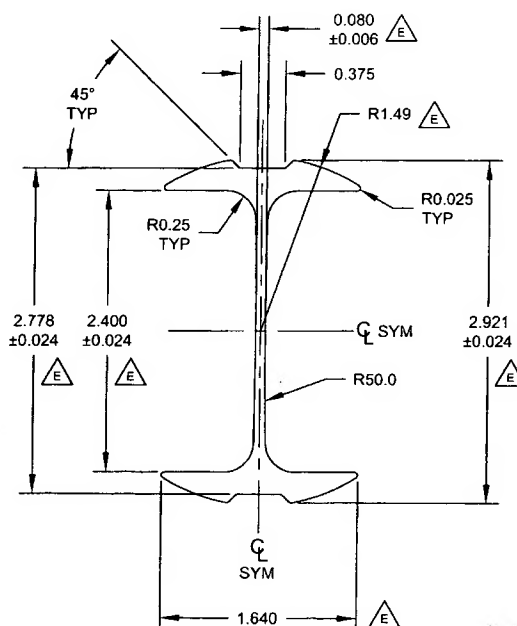
RELEASED
2012-01-10

DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	9		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	E	D2600	SHEET 2 OF 3
APPROVED	WAO	TITLE	SCALE
DE APPR.	#	EXTRUSION	NTS
DATE	11.10.18	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

90531



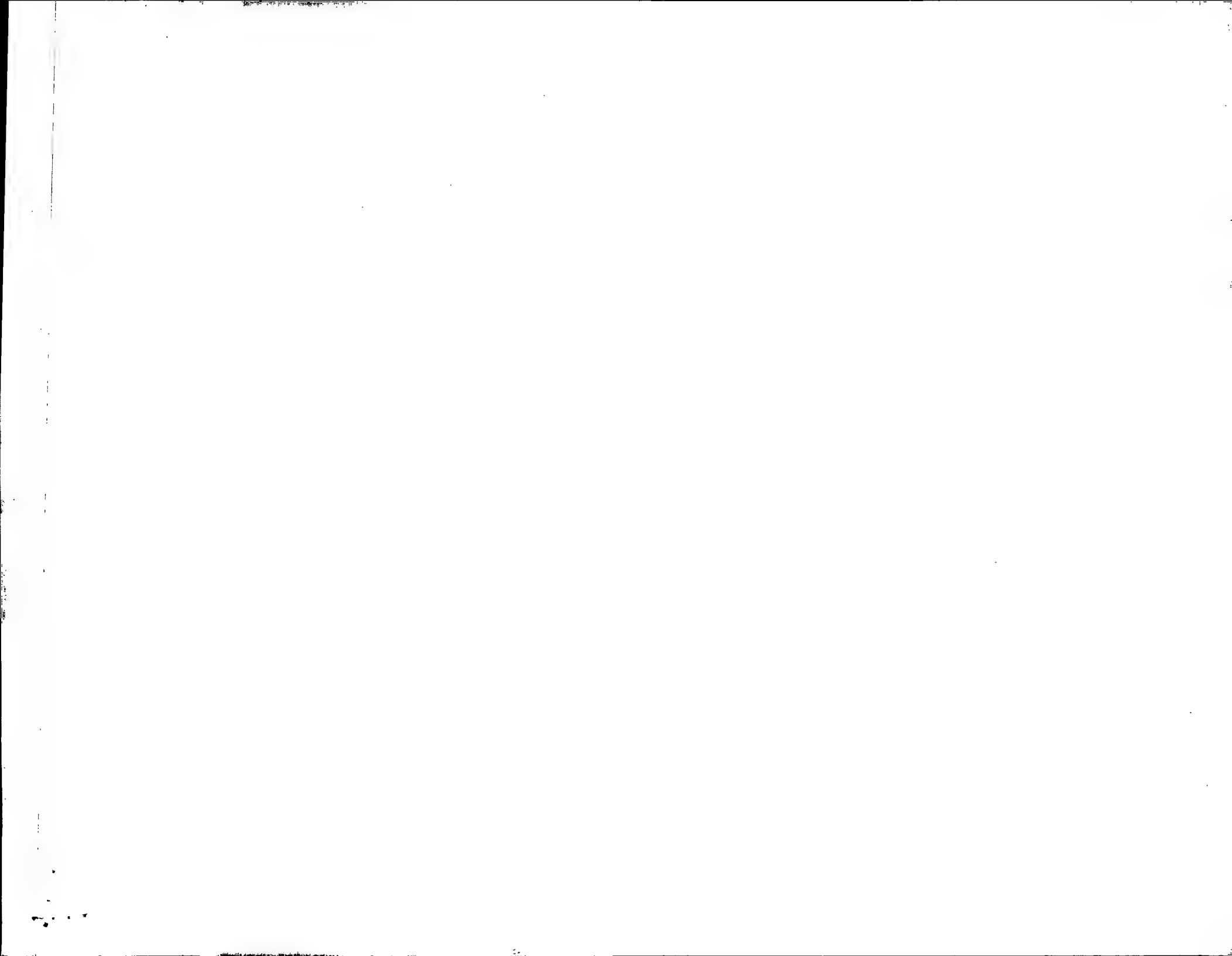
D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
2012-01-11
JW

DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	EL	D2600	SHEET 3 OF 3
APPROVED	#	TITLE	SCALE
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DATE	11.10.18	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17955**

Purchase Order Date 9/20/12

PO Print Date 9/20/12

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name

Vendor Phone 800 563 1079

Vendor Fax 800 565 8339

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2600-1-160P	Extrusion Round 3" 206	10/12/12 Yes	80.00 Each	Yours ppd	\$38.9282	\$3,114.26

Wk 76

Special Inst: EXTRUDE AS PER DWG D2600 REV. E
B90531
MATERIAL: 6061-T6 AS PER QQ-A-200/8
MINIMUM YIELD TENSILE STRENGTH
= 35 KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%
160" LONG
DIE # 897121

PO Total:

\$3,114.26

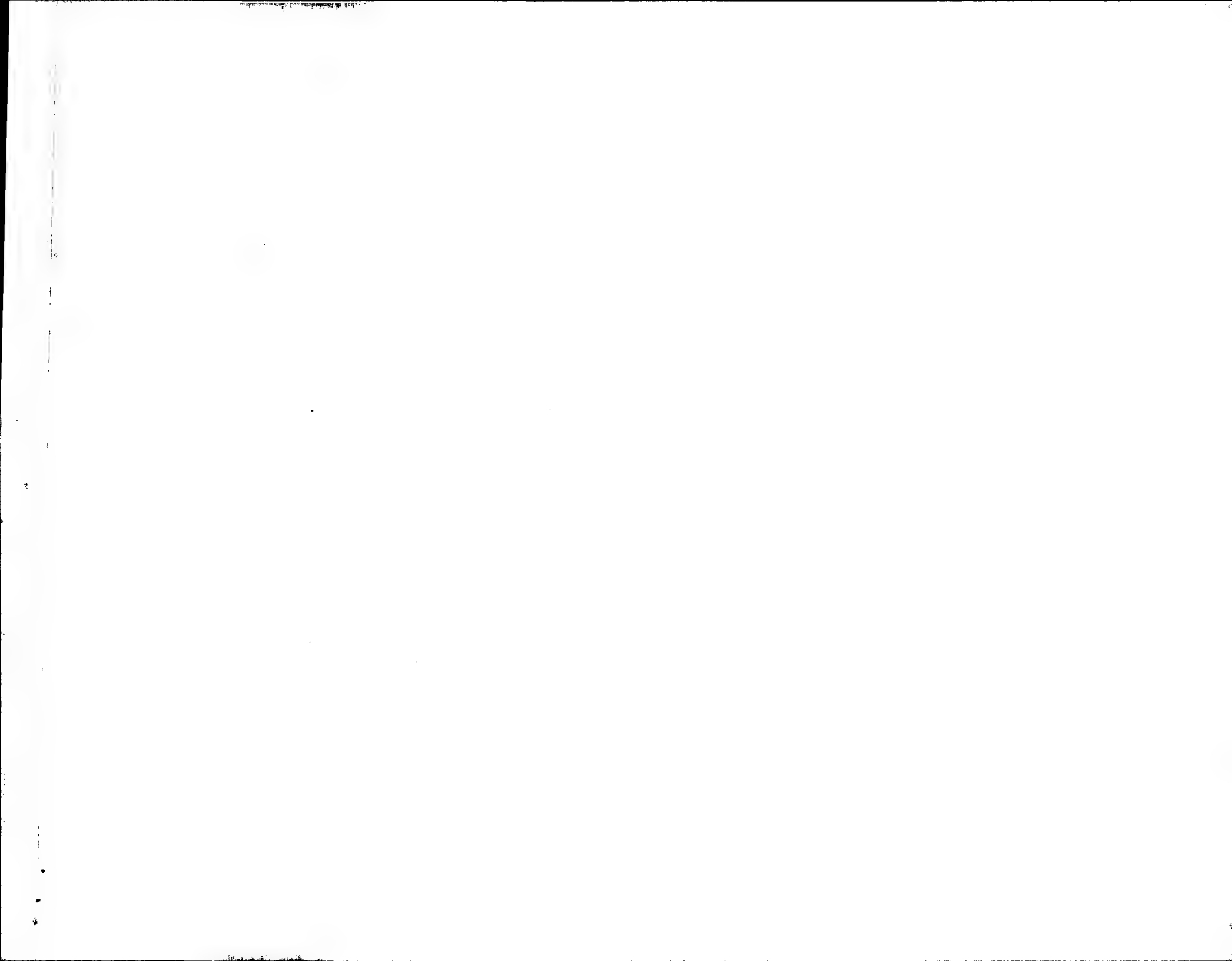
46730

CX

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 2

Change Date: 9/20/12





ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE / DATE DU BODEREAU
10-17-12MANIFEST NUMBER / N° DE BODEREAU
007917SALES ORDER NUMBER / N° DE COM
107462

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE

LOCATION		TRAILER NUMBER / REMORQUE Nombre		SALESMAN / VENDEUR		CREDIT REP / REP DU CRÉDIT		SALES REP / REP. DES VENTES			
PIC		03		042				G.ATTENBOROU			
CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre		JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES			
46024		09/20/12		17955				G.ATTENBOROU			
				BILL OF LADING NUMBER / NO. DE CONNAISSEMENT		CARRIER / TRANSPORTEUR		CUST SERVICE REP / REP. SERVICE CLIENTELE			
				007917		WILRIDE		DLB			
ITEM NO./ NUMERO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,068 LB			DAA-897121-1	6061 T6		2	1,049	1,010 LB		
	484 KG			D2600-1-160	160.0000 IN			476	458 KG		
	80 PC				Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			76 PC		
						816777 / 157528	1	443	423		30 PC
						816777 / 157529	1	606	586		46 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

2	1,049	1,010	LB
	476	458	KG
		76	PC
TOTALS			

DATE OF DELIVERY

DRIVER





SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

10/15/2012	5291455	107462	1
17955	007917	816777	10/17/12

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

001	DAA-897121-1	160" Mill 6061 T6	D2600-1-160
	1,049 LBS		
	1,010 LBS	76 PCS	2 PKGS
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

81716130

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
297.3 / 43.1	269.0 / 39.0	9.5	N/A	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.61	0.27	0.22	0.05	0.86	0.06	0.06	0.02	0.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta, Director of Quality Signature Aluminum Canada Inc

Signature Aluminum Canada

1850 Clements Rd. Pickering, Ontario, Canada L1W 3R8
Local: 905-427-6550 Toll Free: 866-587-5780

Customer: DART AEROSPACE LTD.
Order #: 107462-001-00 Due 10/15/2012

Ship DART AEROSPACE LTD.
1270 ABERDEEN ST.

HAWKESBURY, ON
K6A 1K7

Cust

D2600-1-160



Desc: 160" Mill 6061 T6
Alloy: 6061

Part: DAA-397121-1

Cust

17955



Qty:

46

Pkg 157529



Signature Aluminum Canada

1850 Clements Rd. Pickering, Ontario, Canada L1W 3R8
Local: 905-427-6550 Toll Free: 866-587-5780

Customer: DART AEROSPACE LTD.

Order #: 107462-001-00 Due 10/15/2012

Ship DART AEROSPACE LTD.
1270 ABERDEEN ST.

HAWKESBURY, ON
K6A 1K7

Cust

D2600-1-160



Desc: 160" Mill 6061 T6
Alloy: 6061

Part: DAA-397121-1

Cust

17955



Qty: 30

Pkg 157528



LBs KGS

Gross:	443	201
Tare:	20	9
Net:	423	192

Lot #: 816777



Insp: G1SMITH
Date: 10/15/12